

Date: Thursday, 18/01/2007 7:42:02 AM  
User: J. Lacelle

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services  
Job Number : 30312  
Estimate Number : 12651  
P.O. Number : N/A  
This Issue : 18/01/2007 S.O. No. : N/A  
Prsht Rev. : NC  
First Issue : N/A Type : SMALL /MED FAB  
Previous Run : N/A  
Written By :  
Checked & Approved By :  
Comment : Est Rev :A New Issue 07-01-16 JLM

Drawing Name : R44 WEARPLATE

Part Number : D35651  
Drawing Number : D3565 UNDER REVIEW  
Project Number : N/A  
Drawing Revision : U/R  
Material : N/A  
Due Date : 25/01/2007

Qty: 2 Um: Each

### Additional Product

Job Number:



Seq. #: Machine Operation: Description :

1.0 M304316GA 304/316 Sheet 0.060"



M101873

M 07 01 31



①

Comment: Qty.: 0.3759 sf(s)/Unit Total: 0.7518 sf(s)

304/316 Sheet 0.060"

Batch: M101463

M 07 01 18

M101873 ⑥ SAD

M101873 6 SAD

②

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D3565

Dwg Rev: U/R

Prog Rev: U/R

M 07 01 31 ①

M 07 01 18 ②

SAD 07/02/05 ⑥ ②

2-Deburr if necessary

M 07 01 18 M 07 01 31 ①

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



M 07 01 31 ①

SAD 07/02/05 ⑥

M 07 01 18



②

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

M 07/01/18 ③

5.0 BRAKE NC NC BRAKE



Comment: NC BRAKE

form 90 deg bend as per Dwg D3565

SAD 07/01/19 ③

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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: R44 WEARPLATE

Job Number: 30312

Part Number: D35651

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

R 07-02-05

7.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Form "Cups" using DT8902 FORMING TOOL.

R 02-02-05

2-Open Holes to .257" as per Dwg D3565 after forming.

N/A

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

N/A 07/02/06

9.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Weld hard facing as per Dwg D3565 using DT8903 Holding Plate

A/R 2059B Hard Coat rod

Batch:

M102755

N/A 07/02/06 (6)

10.0

QC5/9

WELD INSPECTION



Comment: WELD INSPECTION

N/A 07-02-06 (6)

11.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

M101601

M-A/Y 07/02/06 (6X)

12.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

R 07-02-06 (6)

13.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

N/A For Eng. use x4 (00062)  
For HAI x2

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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: R44 WEARPLATE

Job Number: 30312

Part Number: D35651

Job Number:



ENGINEERING APPROVAL  
Project Manager:

CB  
07.02.07

Seq. #:

Machine Or Operation:

Description:

14.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

W. 07.02.07

Job Completion



W 07.02.07

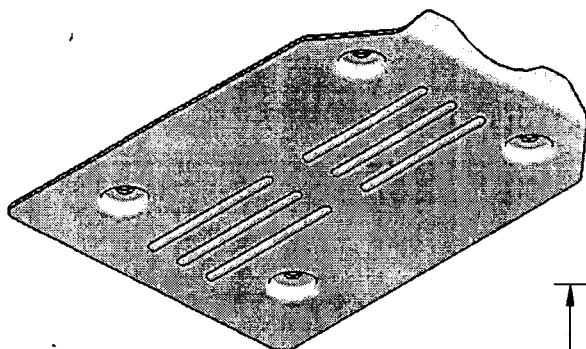
PART WENT TO HAI. PART NOT APPROVED AND NOT AIRWORTHY

CB 07.07.13



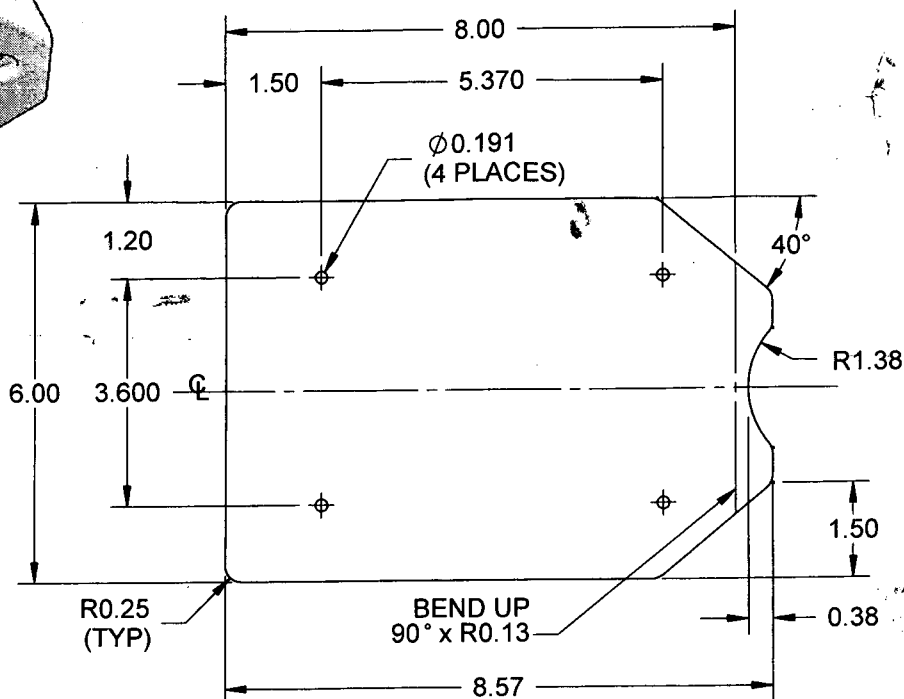
# PRELIMINARY ISSUE

DESIGN <b>CB</b>	DRAWN BY <b>CB</b>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. <b>D3565</b>	REV. A SHEET 1 OF 1
DATE <b>07.01.09</b>	TITLE <b>R44 WEARPLATE</b>		SCALE 1:3
REV <b>A</b>	DATE <b>07.01.09</b>	DESCRIPTION <b>NEW ISSUE</b>	

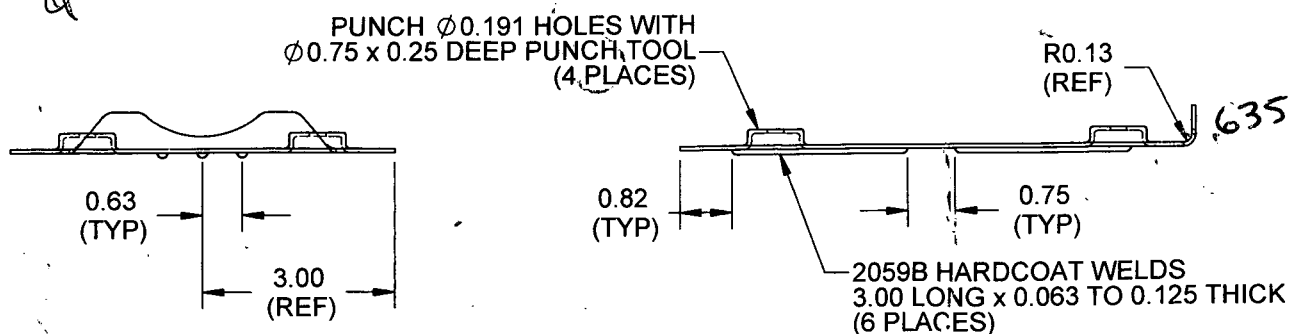


**UNDER REVIEW**

07.01.12 CB



**D3565-1F FLAT PATTERN**



**D3565-1 R44 WEARPLATE**

**NOTES:**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 20 GAUGE (0.038 THICK, (REF DART SPEC M304S20GA)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT "GREY SANDTEX" (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3565-1F" USING FINE POINT PERMANENT INK MARKER
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 7) WELD PER QSI 004
- 8) PART IS SYMMETRIC ABOUT C

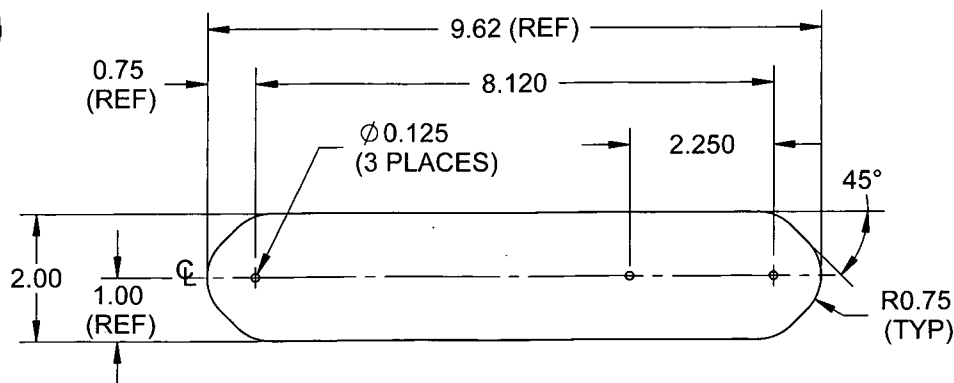
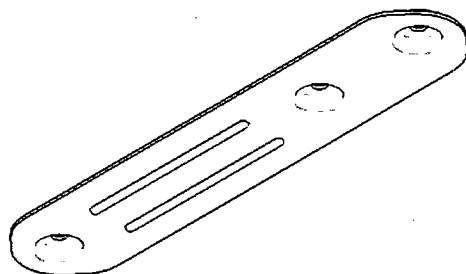
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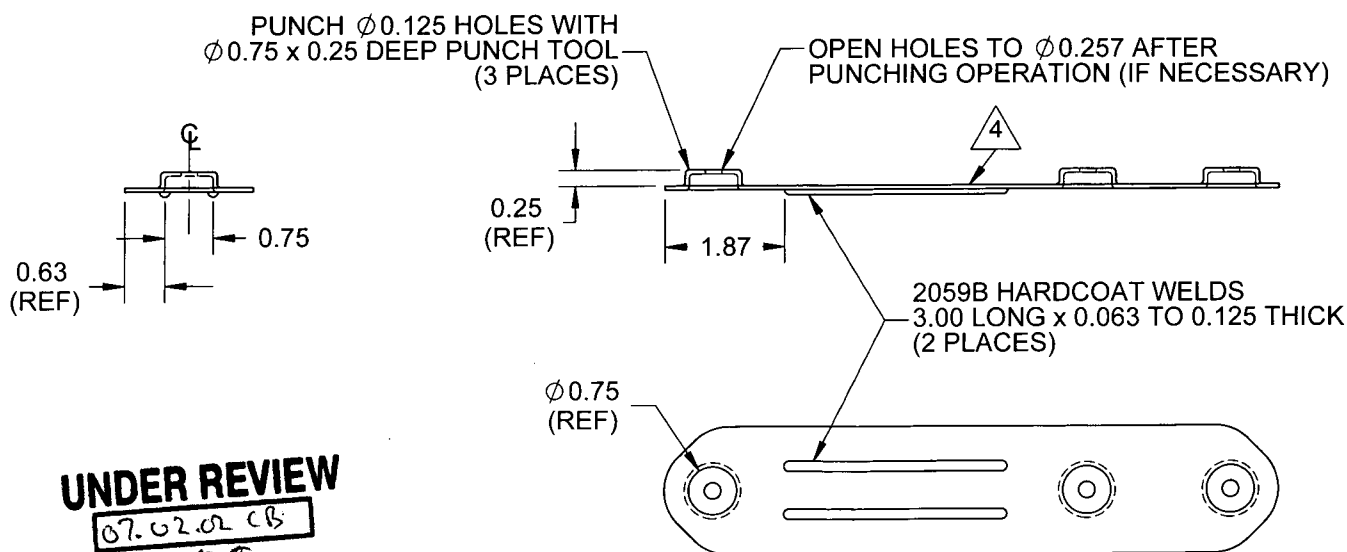


# PRELIMINARY ISSUE

DESIGN CB	DRAWN BY CB	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED	DRAWING NO. D3565	REV. A SHEET 1 OF 1
DATE 07.01.09	TITLE R44 WEARPLATE		SCALE 1:3
REV A	DATE 07.01.09	DESCRIPTION NEW ISSUE	



## D3565-1F FLAT PATTERN



**UNDER REVIEW**

07.02.02 CB  
prototype

## D3565-1 R44 WEARPLATE

### NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 16 GAUGE (0.063 THICK) (REF DART SPEC M304S16GA)
- 2) FINISH: POWDER COAT "GREY SANDTEX" (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3565-1F" USING FINE POINT PERMANENT INK MARKER
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 7) WELD PER QSI 004
- 8) PART IS SYMMETRIC ABOUT C

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## Receiving Report

Date: 06/08/18  
Supplier: Camp

Batch No: 11101873  
Dart P/O: 1709

Packing Slip: Yes ☒ No ☐  
Invoice: Yes ☐ No ☒  
Receipt: Cash ☐ Cr ☐

Release Note Attached: Yes ☐ No ☒ N/A ☐  
Waybill Attached: Yes ☐ No ☒ N/A ☐  
Shipment Complete: MS Yes ☒ No ☐ N/A ☐  
QC6 Inspection 06/08/18 N/A ☐  
Work Order                     

### Discrepancies

Part Number	Description	Quantity Ordered	Quantity Received	Quantity Returned	Quantity Short	Comments

Initials of receiver (If shipment OK) Level 12 CZ

Production/Admin: 06/08/18  
Date: RCP 2314  
Received/Costing: CZ  
Initial:           

Location                     

95010

Chemical Composition											
Heat No.	C	Si	Mn	P	S	Cr	Ni	Cu	Al	Mo	N
4500933	0.050	0.480	1.320	0.023	0.002	18.130	8.050				0.050
4500933	0.050	0.480	1.320	0.023	0.002	18.130	8.050				0.050
AHLN1312	0.053	0.481	1.109	0.029	0.003	18.290	8.100				0.031
4502513	0.060	0.470	1.340	0.014	0.002	18.080	8.140				0.050
Y503096	0.054	0.430	1.050	0.031	0.004	18.180	8.120				0.063
4502523	0.050	0.500	1.340	0.016	0.002	18.040	8.060				0.060
Mechanical Properties											
Test No	Tensile R <sub>m</sub> N/mm <sup>2</sup>	R <sub>p0.2</sub> Yield <sub>0.2%</sub> N/mm <sup>2</sup>	R <sub>p1.0</sub> Yield <sub>1.0%</sub> N/mm <sup>2</sup>	Elongation A5%	Corrosion Tests	Hardness					
						HRB	HV	HRC			
4500933-T	645	295		58			174				
4500933-T	645	295		58			174				
AHLN1312-T	685	294		54			182				
4502513-T	650	301		61		84 - 83					
Y503096-I	665	319		57		86 - 86					
4502523-T	640	297		62		83 - 82					
-T											

Surface and dimensions controlled: O.K.

# METALLURGICAL TEST REPORT



**NORTH AMERICAN STAINLESS CANADA, INC.**

NORTH AMERICAN STAINLESS CANADA  
740 IMPERIAL ROAD NORTH  
GUELPH, ON N1K1Z3

Certificate: 6551 2 Mail To:

Ship To:

Date: 3/15/2006 Page: 1

Customer: 007035 002

Steel: 304

Finish: 2B

Your Order: 73-02485

NAS Order: PN 0000217 02

Corrosion: ASTM A262/02a5, 180 bend-GK

## PRODUCT DESCRIPTION:

STAINLESS STEEL COIL, COLD ROLLED, ANNEALED AND PICKLED.  
ASTMA240/05a, 480/05, 666/03, ASMEHA240/04-A05, 480/04-A05, SA666/04  
Q05766D-A X NO PPM, AMS5513H X HARELIN, MEL5059D, AND 1, X CRWN MEAS  
WHEN PURCHASING SPEC. REVISED 8/97

## REMARKS:

Material free from mercury contamination. No weld repairs.  
EN 10204 3.1 PED 97/23/EC Annex I, Para. 4.3 Q05763F Cond A  
Material is RoHS-Compliant

Product Id	Coil #	Thickness	Width	Weight	Length	Mark	Pieces	Commodity Code
0391R2 A	0391R2 A	.0575	48.0000	15,420 COIL		3	1	

## CHEMICAL ANALYSIS CM(Country of Melt) ES(Spin) US(United States)

Heat	CM	C	CR	CU	MN	MO	N	NI	P	S	SI
91R2	US	.056	18.008	.302	1.709	.258	.047	8.151	.027	< .001	.325

## MECHANICAL PROPERTIES

Product Id#	Coil #	1 d o i o r	UTS KSI	.2% YS KSI	ELONG %-2"	Hard RB	Tail Hard
0391R2 A	0391R2 A	F T	93.69	42.28	56.14	81.50	86.00

**RECEIVED**  
1 MAR 16 2006

BY:

QC ENGINEER

ERIC HESS

3/15/2006

# DAKI

Dart Aerospace Ltd  
1270 Aberdeen St  
Hawksbury, Ontario K6A 1K7  
Phone: (613)632-9577  
Fax: (613)632-1053

Purchase Order number  
PO00001704

**FAKED**  
08/25/06

*Confirmation # C46*

**Vendor Address:**

Campi Steel  
935 Boul. Du Havre  
Valleyfield, QC J6S 5L1  
Phone (800) 667-4248  
Fax (450) 377-5696

**Ship To:**

Main Finished Goods Location  
Dart Aerospace Ltd  
1270 Aberdeen St  
Hawksbury, Ontario K6A 1K7

Reference	Contact	Vendor Number	PO Date	Terms	Ship Via	Expected Arrival
		VC-CAM002	Jul 17, 2006	N30	PREPAID	Jul 21, 2006

Qty. Ordered	Item Number	Description	Expected Arrival	Drop-Ship	Unit Cost	UOM	Extended Price
64.0000	M304S14GA	304SS .080 Comments: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH	7/21/2006	No	7.950000	sf	508.80 OK
320.0000	M304S16GA	304/316 .063 Sheet Comments: AS ABOVE	7/21/2006	No	7.700000	sf	2,464.00 OK
320.0000	M304S20GA	304/316 .040 Sheet Comments: * MUST BE 20 GA * ATTN: PLS SHIP ALL STOCK AVAILABLE- DO NOT HOLD FOR B/O'S - SHIP BALANCE WHEN READY	7/21/2006	No	4.750000	sf	1,520.00 OK
Comments:		<b>Tax Summary:</b> GST 269.57 GSTME 0.00 GSTND 0.00		Less: included tax 0.00		0.00	
				Subtotal		4,492.80	
				Total tax		269.57	
Entered By: CLAVOIE				Total purchase order in			
Approved By: <i>[Signature]</i>				CAD Dollars		4,762.37	